

Date: Monday, 11/08/2008 1:52:36 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: PLUG	
Job Number	: 41112				Part Number	: D26511	
Estimate Number	: 10512				Drawing Number	: D2651 REV. B	
P.O. Number	:				Project Number	: N/A	
This Issue	: 11/08/2008		S.O. No. :	Type : MACHINED PARTS		Drawing Revision	: B
Prsht Rev.	: NC				Material	:	
First Issue	: / /		Type	: MACHINED PARTS		Due Date	: 15/08/2008
Previous Run	: 40435				Qty:	200	Um: Each
Written By	:						
Checked & Approved By	: JWD 08-8-11						
Comment	: Est: A 02.04.15 New Issue NG						
	Est: B 05.12.12 added deburr EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0500	6061-T6 Round Bar .500"	
		Comment: Qty.: 0.0421 f(s)/Unit Total : 8.4210 f(s) Material: 6061-T6 (QQ-A-225/8) 0.500" Dia (M6061T6R0500) Batch: M107676 (52 inches) = 111 piece	M107676 = 111 piece
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			Total 203
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Turn as per Folio FA219 and Dwg D2651	
		2- Deburr	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr as per dwg D2651	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/08/2008 1:52:36 PM
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Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

22/Fd. 08/08/21 4203

7.0 POWDER COATING

POWDER COATING



m108523

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(Only larger section necessary)

START TIME: 9:00

OVEN TEMPERATURE: 320°

FINISH TIME: 9:30

Fd 08/08/22

203

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-h

08/08/25

203x

9.0 PACKAGING 1

PACKAGING RESOURCE #1



203x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F-P A

M-h 08/08/25

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/25 FJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



108/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41112
Description: Plug	Part Number:	D2651-1
Inspection Dwg: D2651 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	08/08/11	Date:	08/08/21	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.22	New Issue	KJ/RF	PP



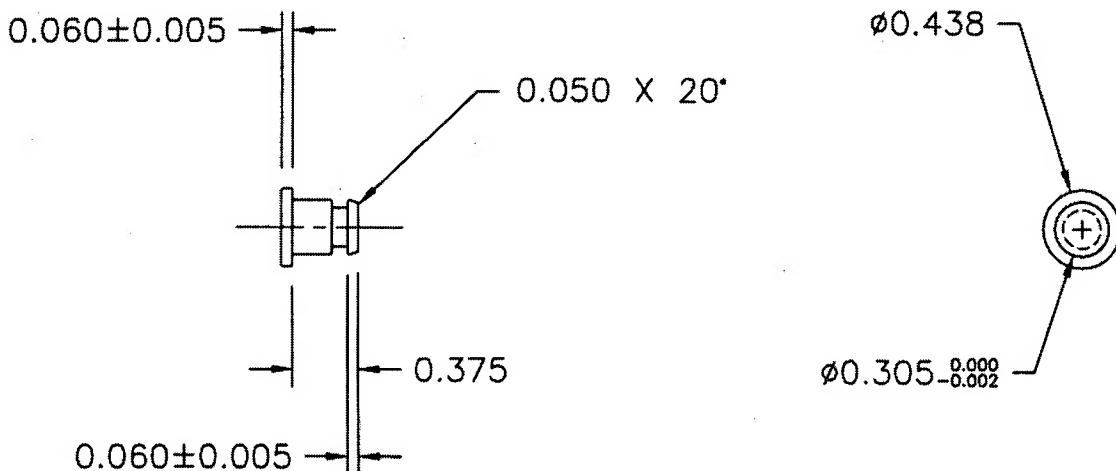
OF COPY
ONE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D2651		SHEET 1 OF 1
DATE		TITLE	SCALE	
03.12.19		PLUG	1:1	
A	97.03.25	NEW ISSUE		
B	03.12.19	ADD POWDER COAT, MS28775-008		

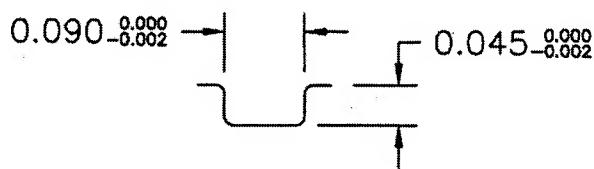
RELEASED

03.12.19 ✓

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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NO. 4112

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